

TECHNICAL DATA SHEET

GRIVORY HB 5299

General product description

Grivory HB 5299 is a lubricated, lactam free copolyamide, especially developed for high barrier (oxygen, carbon dioxide) packaging solutions.

- Excellent oxygen and carbon dioxide barrier, especially in interaction with moisture (50 up to 100% relative humidity)
- Excellent transparency, even with thick component parts
- Suitable as a middle layer in multi-layer films and component parts
- Suitable for co-extruded and oriented multi layer films in conjunction with all kind of Polyamides, Polyesters and Polyolefins
- Barrier properties are not affected by steam sterilisation (transparency gets lost)

Application

Grivory HB 5299 is used in various multi layer structures providing high barrier (oxygen, carbon dioxide, nitrogen, ...), e.g. Co-extrusion blown and cast films.

GRIVORY®
EMS

PROPERTIES

Thermal Properties

		Standard	Unit	Grivory HB 5299
Melting point	DSC	ISO 11357	°C	218
Melt volume rate (MVR)	275°C / 5 kg	ISO 1133	ml/10 min	50

General Properties

Density		ISO 1183	g/cm ³	1.21
Water absorption	23°C/sat.	ISO 62	%	5.5
Moisture absorption	23°C/50 % r.h.	ISO 62	%	2.0
Shrink ¹⁾		EMS	%	-
Gloss	60°	ISO 2813	-	150
Haze		ISO 14782	%	-

Barrier Properties (50 µm films)

O ₂ -Transmission rate	23°C/ 0 % RH	DIS/ISO 15105-1	cm ³ /m ² 24h bar	4
	23°C/85 % RH		cm ³ /m ² 24h bar	4
CO ₂ -Transmission rate	23°C/ 0 % RH	DIS/ISO 15105-2	cm ³ /m ² 24h bar	15
	23°C/85 % RH		cm ³ /m ² 24h bar	15
Moisture vapour transmission rate	23°C/85 % RH	DIS/ISO 15106-1	g/m ² 24h	6

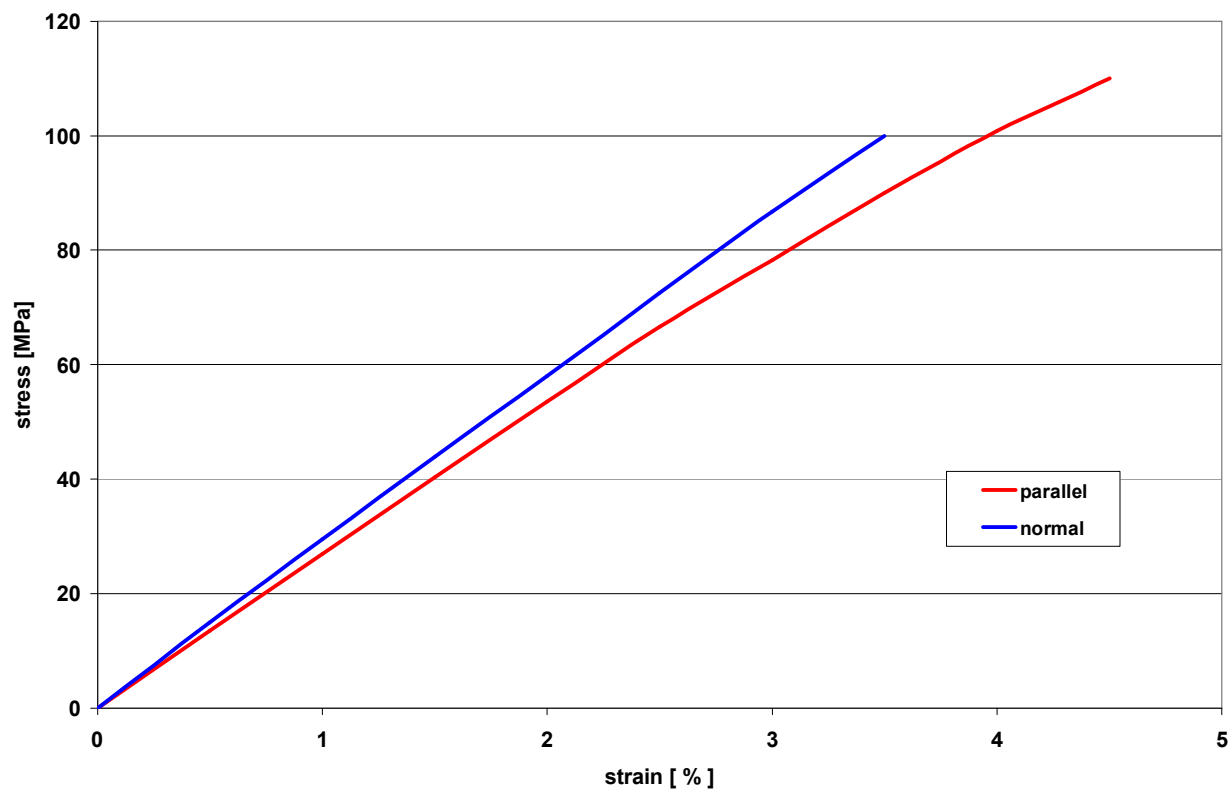
Mechanical Properties

Tensile E-Modulus	4 mm bar	ISO 527-2	MPa	4000
Stress at yield	parallel	ISO 527-3	MPa	*
	normal			*
Strain at yield	parallel	ISO 527-3	%	*
	normal			*
Stress at break	parallel	ISO 527-3	MPa	110
	normal			100
Strain at break	parallel	ISO 527-3	%	4.5
	normal			3.5
Tear resistance	parallel	ISO 6383-1	N/mm	10
	normal			10
Elmendorf tear resistance	parallel	ISO 6383-2	N	5
	normal			5
Dart drop impact	A	ISO 7765-1	g	-
	B			-
Gelboflex test	900 cycles	EMS	holes/ m ²	-

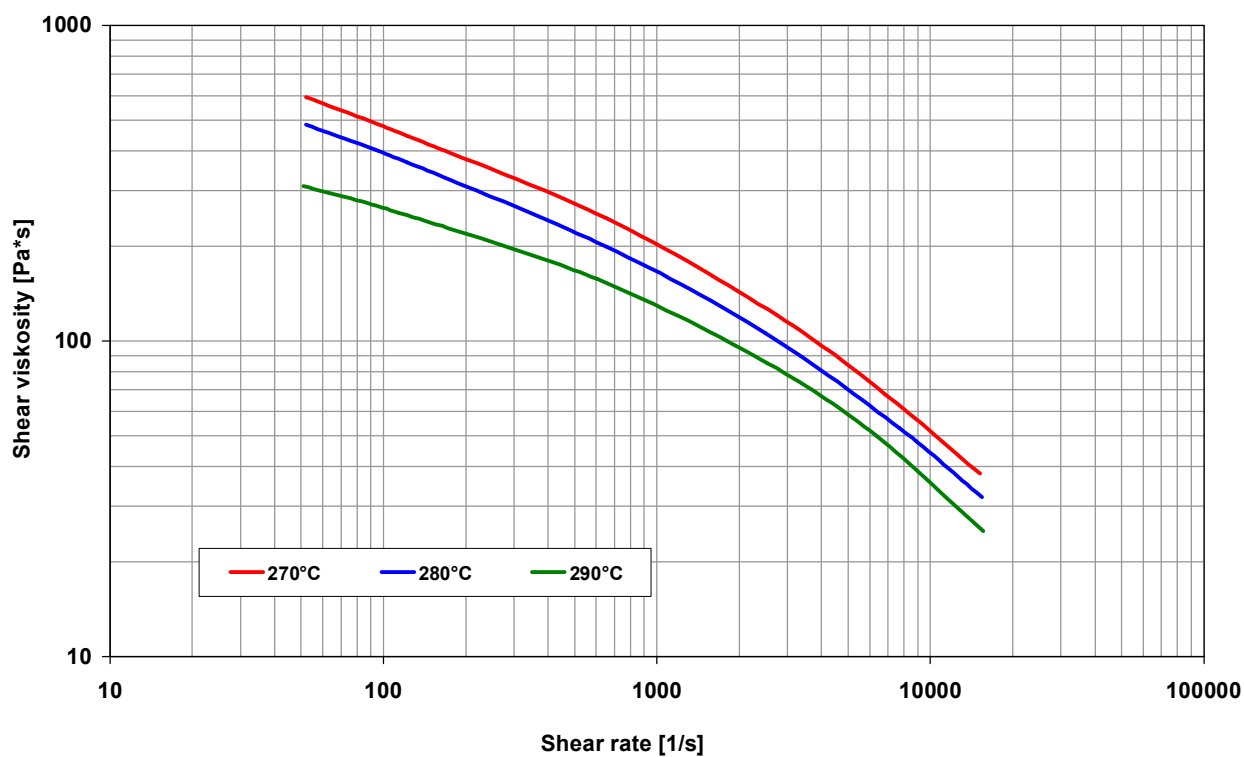
Product nomenclature acc. ISO 1874: PA MXD6/MXDI, FNST, 12-040

¹⁾ 80 µm film applied on 160 µm Ionomer, biaxially oriented at 70°C (draw ratio 2:1), afterwards shrinkage in water at 85°C

Stress & Strain Grivory HB 5299



Viscosity function Grivory HB 5299



Processing information for the extrusion of Grivory HB 5299

This technical data sheet for Grivory HB 5299 provides you with useful information on material preparation, machine requirements and processing.

MATERIAL PREPARATION

Grivory HB 5299 is delivered dry and ready for processing in sealed, air tight packaging. Predrying is not necessary.

Storage

Sealed, undamaged bags can be kept over a long period of time in storage facilities which are dry, protected from the influence of weather and where the bags can be protected from damage.

Handling and safety

Detailed information can be obtained from the "Material Safety Data Sheet" (MSDS) which can be requested with every material order.

Drying

Grivory HB 5299 is dried and packed with a moisture content of less than 0.10 %. The processing of moist material reduces the optical and mechanical quality of the application. A too high moisture content can result in fish eyes, streaks and brittleness.

The drying can be done as follows:

Desiccant dryer

Temperature:	max. 80°C
Time:	4 - 12 hours
Dew point of the dryer:	-40°C

Vacuum oven

Temperature:	max. 100°C
Time:	4 - 12 hours

Drying time

If there is only slight evidence of foaming of the melt or just traces of silver streaks on the part, then the above mentioned minimal drying time will be sufficient. Material, which is stored in open over days, which shows strong foaming, is unusually easy flowing melt or streaks on the article, then the maximal drying time is required.

Drying temperature

Polyamides are subjected to the affects of oxidation at temperatures above 80°C in the presence of oxygen. Visible yellowing of the material is an indication of oxidation. Hence temperatures above 80°C for desiccant dryers and temperatures above 100°C for vacuum ovens should be avoided.

At longer residence times (over 15 minutes) hopper heating or a hopper dryer (80°C) is useful.

MACHINE REQUIREMENTS

Grivory HB 5299 can be processed economically and without problems on all extrusion lines suitable for polyamides.

Screw

Wear protected, Universal 3 zone screws are recommended.

Screw

Length:	24 D - 30 D
Compression ratio:	2.5 - 3.5

Heating

At least three separately controllable heating zones, capable of reaching cylinder temperatures of up to 270°C are recommended. The cylinder flange and adapter must be able to be heated.

PROCESSING

Temperatures

For the start up of processing Grivory HB 5299 on film extrusion lines the following parameters are recommended:

Temperatures

Hopper	15 - 60°C
Zone 1	240 - 260°C
Zone 2	240 - 260°C
Zone 3	240 - 260°C
Adapter	240 - 260°C
Die	240 - 260°C
Melt	240 - 260°C

In cases where the use of grooved feed zones is employed it is recommended to temper this zone between 60 and 120°C.

CUSTOMER SERVICES

EMS-GRIVORY is a specialist in polyamide synthesis and the processing of these materials. Our customer services are not only concerned with the manufacturing and supply of engineering thermoplastics but also provide full technical support including:

- Rheological design calculation / FEA
- Prototype tooling
- Material selection
- Processing support
- Mould and component design

We are happy to advise you. Simply call one of our sales offices.

The recommendations and data given are based on our experience to date, however, no liability can be assumed in connection with their usage and processing.

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This version replaces all previous product specific data sheets

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